

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021564**Date Inspected:** 25-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng /Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path/Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 10 – Tower Shop

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 051 located on BK008A3-001. Welder is identified as 053869. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 051 located on BK008A3-001. Welder is identified as 053869. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 014 located on BK008A4-001. Welder is identified as 057258. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 015 located on BK008A4-001. Welder is identified as 057075. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay 11 – Tower Shop

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

## In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 072 located on BK004A6-023. Welder is identified as 040723. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 003 located on BK004A6-023. Welder is identified as 054460. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

## Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07488.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK004A6-030-025, 159, 027, 125, 037, 161, 039, 128, 003, 152, 005, 153

BK004A6-030-008, 156, 010, 157

BK004A6-030-004, 150, 006, 151, 009, 154, 011, 155

## Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07488.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK004A6-030-025, 159, 027, 125, 037, 161, 039, 128, 003, 152, 005, 153

BK004A6-030-008, 156, 010, 157

BK004A6-030-004, 150, 006, 151, 009, 154, 011, 155

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07495.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

WSD1-FASA6-4-15, 16, 22, 23

WSD1FESA6-4-1, 2, 3, 4, 17, 18, 19, 20

ESD1-FASA6-2-1, 2, 3, 4, 5, 6, 7, 8, 9, 10

WSD1-FASA6-4-1, 2, 3, 4, 5, 6, 7, 8, 9, 10

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Leavitt, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

---